

Date: Tuesday, 8/21/2007 3:43:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34192
 Estimate Number : 12926
 P.O. Number :
 This Issue : 8/21/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 33944
 Written By :
 Checked & Approved By : JP 08/08/07
 Comment : Est Rev: A New Issue 07-07-04 JLM

Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
 REVIEW
 Part Number : D29384
 Drawing Number : D2938 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 9/20/2007 Qty: 8 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length

(D6101-003)

Batch No: B34873

JP 08/03/06

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet

5-Deburr

JP 08/03/06

JP 08/03/06

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JP 08/03/06

JP 08/03/06

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

JP 08/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/03/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 34192

Part Number: D29381UP

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/03/10

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HJ 08-03-10

(x8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L 08/03/11

(8X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY29

AS 08/03/12

(x8)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DOE 08/03/12

(8)

Job Completion



66. powder not white
per ST-005

M 107005

FL 08/03/11 (8)

mi 2008/3/12 (8)

MF 08/03/27 (8)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34192
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.130	0.130	0.132	0.131		
B	0.100	0.140		0.130	0.130	0.129	0.129		
C	0.100	0.140		0.116	0.117	0.115	0.119		
D	0.210	0.230		0.219	0.220	0.219	0.220		
E	1.245	1.255		1.249	1.249	1.249	1.249		
F	1.245	1.255		1.2485	1.250	1.250	1.250		
G	2.495	2.505		2.499	2.499	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510			
I	1.572	1.582		1.576	1.5775	1.577	1.5775		
J	2.495	2.505		2.4985	2.500	2.500	2.501		
K	0.257	0.262		0.259	0.260	0.2595	0.2596		
L	0.312	0.317		0.3145	0.314	0.314	0.314		
M	0.235	0.240		0.2395	0.240				
N	0.100	0.140		0.109	0.1105	0.110	0.112		
O	0.540	0.560		0.546	0.5455	0.547	0.545		
P	0.490	0.510		0.499	0.495	0.494	0.493		
Q	3.715	3.725		3.722	3.718	3.720	3.720		
R	2.720	2.760		2.741	2.739	2.740	2.742		
S	0.240	0.270		0.255	0.256	0.255	0.2555		
T	0.100	0.180		0.160	0.160	0.160	0.160		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.366	1.367	1.367	1.3666		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.250	1.270		1.254	1.2553	1.2544	1.2566		
Y	1.565	1.585		1.569	1.5693	1.569	1.570		
Z	0.178	0.198		0.1875	0.1875	0.1875	0.1875		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DJP
Date:	08/03/06

Audited by:	J.F.
Date:	08/03/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34192
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

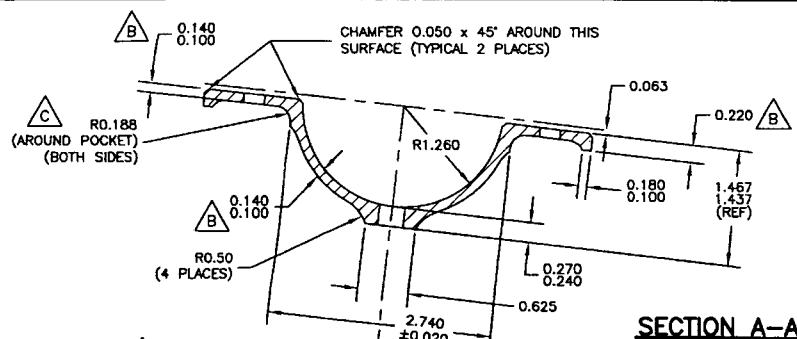
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.140	.133	.120	.120		
B	0.100	0.140		.135	.135	.125	.125		
C	0.100	0.140		.135	.135	.125	.125		
D	0.210	0.230		.220	.219	0.221	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.240	0.240	.235		
N	0.100	0.140		.122	.125	0.111	.108		
O	0.540	0.560		.550	.549	.550	.550		
P	0.490	0.510		0.495	.496	.496	.496		
Q	3.715	3.725		3.720	3.720	3.721	3.721		
R	2.720	2.760		2.750	2.751	2.750	2.750		
S	0.240	0.270		.250	.250	.250	.250		
T	0.100	0.180		.160	.160	.160	.160		
U	1.625	1.635		1.625	1.625	1.625	1.625		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		0.321	0.321	0.321	.321		
X	1.250	1.270		1.254	1.254	1.255	1.255		
Y	1.565	1.585		1.569	1.569	1.570	1.570		
Z	0.178	0.198		0.1875	0.1875	0.1875	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

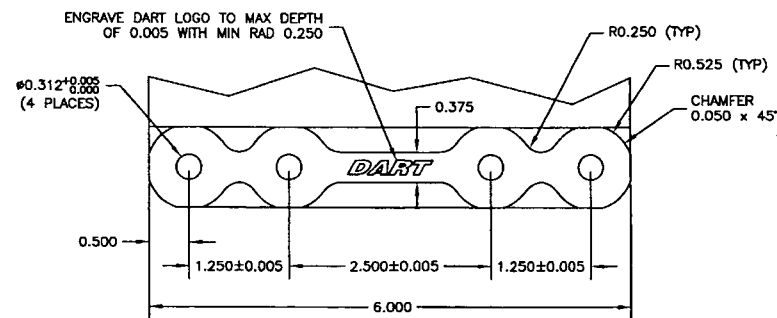
Measured by:	DJP / JF
Date:	08/03/07 / 08/03/07

Audited by:	J.F. #
Date:	08/03/10

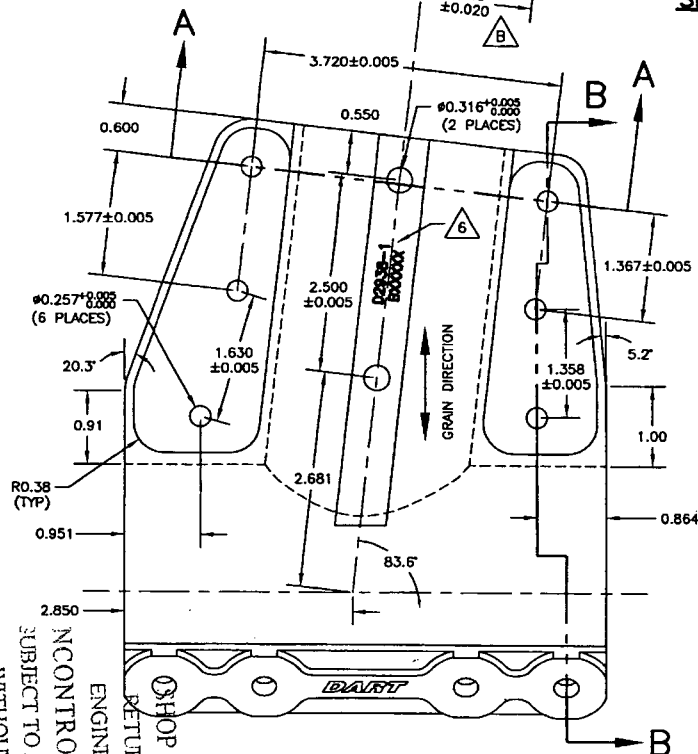
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
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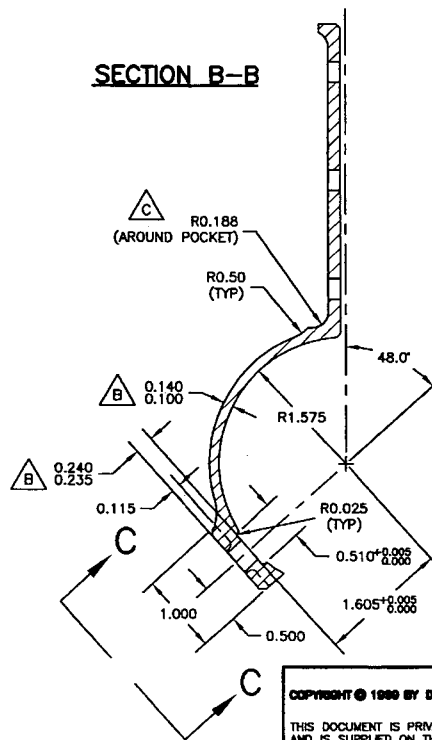
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	SADDLE OUTSIDE
06.11.09		REV. C SHEET 1 OF 1 SCALE

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